



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3110

Job Sheet 196018



Part No: 646.3110

Job Qty: 20 pcs

Part Name: Channel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/4/19

Job Tracking No:

Due Date: 6/28/19

Created By: Marie Lajeunesse

Type: ~~Stock~~ *SOLD*

Description:

Note: DWG 646.3100 REV N/C IPP REV:A NEW ISSUE 12-10-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		6/28/19	0.00	1.10	Bandsaw - 1		<i>DJP 19-06-21</i>
110	HAAS 4 Axis - B4B	20 pcs		6/28/19	0.43	22.22	HAAS - 1 - B4B		<i>DJP 19-06-21</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	20 pcs		6/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S192731



Part: 646.3110

Job No: 196018

Serial No/Batch: S192731

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/21/19

PCS
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	DJP A-06-21
					QC 2 - 69	
					QC 8 - 12	
130 QC 8	20 pcs	6/28/19	0.00	0.00	QC 8 - 14	ML 19/06/23
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140 Outsource - 2 - NDT per QSI038 <i>ANODIZE</i>	20 pcs	6/28/19			ATG001-VC	8 <i>2019-06-28</i>
150 Packaging 2-1 - Receive - B4B <i>[Signature]</i>	20 pcs	6/28/19	0.00	0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	<i>[Signature]</i> JUL 15 2019
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	

					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
155 QC 5	20 pcs	6/28/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
180 Packaging 3-1 - Stock - B4B	20 pcs	6/28/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	

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JUL 16 2019

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC CC 1020
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	6/28/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	3-69 JUL 17 2019
Part Op 100 - Cut Blank at 15.00"					
Descriptions: 110 - 1-Machine per folio FB145					
120 - (QC2- Inspect parts off machine FAI/FAIB)					
130 - (QC8- Inspect parts - second check)					
140 - Issue P/O to ATG : 43880 1- Hard Anodize Black and Prime as per Dwg 646.3100					
150 - (Receive & Inspect for Damage & Mat'l Certs)					
155 - (QC5- Inspect part completeness to step on W/O)					

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180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

MAT
used

18.812'

6.270'

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.500X1.500	7075-T6S Sheet 1.5" Thick Plate X 1.5" Wide	25 ft (1.25 ea)	100-Bandsaw - 1	15x5156194

① 5x5x38087-6.270'

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.500X1.500	25	45	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Channel	14.600inches ± 0.010	14.610 14.590	14.600	
2	Channel	13.130inches ± 0.010	13.140 13.120	13.130	
3	Channel	0.090inches ± 0.010	0.100 0.080	0.09	
4	Channel	0.470inches ± 0.010	0.480 0.460	0.475	
5	Channel	0.750inches ± 0.010	0.760 0.740	0.752	
6	Channel	83.000Degrees ± 0.500	83.500 82.500	83.2	Angle
7	Channel	0.880inches ± 0.010	0.890 0.870	0.881	
8	Channel	0.645inches ± 0.005	0.650 0.640	0.645	
9	Channel	0.110inches ± 0.010	0.120 0.100	0.112	
10	Channel	0.120inches ± 0.010	0.130 0.110	0.120	
11	Channel	0.209inches + 0.005 - 0.001	0.214 0.208	0.211	Diameter
12	Channel	0.409inches ± 0.005	0.414 0.404	0.410	
13	Channel	0.420inches ± 0.002	0.422 0.418	0.421	
14	Channel	2.188inches ± 0.002	2.190 2.186	2.187	
15	Channel	2.188inches ± 0.002	2.190 2.186	2.187	
16	Channel	2.188inches ± 0.002	2.190 2.186	2.188	
17	Channel	2.187inches ± 0.002	2.189 2.185	2.187	
18	Channel	0.785inches ± 0.002	0.787 0.783	0.786	
19	Channel	2.395inches ± 0.002	2.397 2.393	2.397	
20	Channel	0.669inches ± 0.002	0.671 0.667	0.669	
21	Channel	0.372inches ± 0.002	0.374 0.370	0.372	
22	Channel	0.334inches ± 0.002	0.336 0.332	0.334	
23	Channel	0.175inches ± 0.002	0.177 0.173	0.173	
24	Channel	0.130inches ± 0.002	0.132 0.128	0.128	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043880



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043880

PO Date: 6/28/19

Due Date: 7/19/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-07-05

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196018	646.3110	Channel : Various STC's Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed -		7/19/19	20 pcs	0 pcs	20 pcs	\$11.99/pcs	\$239.80
2	193380	646.3713	Gusset : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed -		7/19/19	20 pcs	0 pcs	20 pcs	\$17.09/pcs	\$341.80
3	196619	RBEL133M- 6201-101-7	Rod End -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed -		7/19/19	8 pcs	0 pcs	8 pcs	\$5.09/pcs	\$40.72
4	192397	D4824-1	Upper Cutter Mount : Various STC's Issue P/O: Black Anodize as per Dwg D4824 PRIME AS PER DWG, SEE NOTE #2	Firmed -		7/19/19	8 pcs	0 pcs	8 pcs	\$14.74/pcs	\$117.92
5	193142	646.3714	Gusset : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700 Rev. A	Firmed -		7/19/19	24 pcs	0 pcs	24 pcs	\$17.09/pcs	\$410.16

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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043880



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	196714	RBT18700-101-27	Handle Ends -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; Aluminum -Certificate of Conformity is required	Firmed	-	7/19/19	4 pcs	0 pcs	4 pcs	\$5.09/pcs	\$20.36
7	196512	SWA6A-800B	Connector Bushing (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	-	7/19/19	28 pcs	0 pcs	28 pcs	\$5.09/pcs	\$142.52
										Grand Total: \$1,313.28	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918182

Date: 11-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 20 ea	Part: 646.3110 ✓ Channel Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25393 PO: POHB043880 ✓		Rev: NC Line: 1
✓ 20 ea	Part: 646.3713 ✓ Gusset Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25394 PO: POHB043880 ✓		Rev: A Line: 2
✓ 8 ea	Part: RBEL133M-6201-101-7 ✓ Rod End Anodize per MIL-A-8625F, Type II, Class1, Clear, .0004-.0010" (.4 - 1 mils) Job: 25395 PO: POHB043880 ✓		Rev: Line: 3
✓ 8 ea	Part: D4824-1 ✓ Upper Cutter Mount Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing.		Rev: A

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JUL 11 2019

DAVE AEROSPACE LTD.

Made in Canada.

RECEIVED

JUL 11 2019

DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918182

Date: 11-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Job: 25396 PO: POHB043880	Line: 4	
✓ 21 ea	Part: 646.3714 ✓ Gusset Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25397 PO: POHB043880 ✓	Rev: A Line: 5	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUL 11 2019</u> Certified Signature: <u>_____</u> Receiver Signature: <u>_____</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			